

**PRODUCT DESCRIPTION**

A soft , colorable unfilled SBS based thermoplastic elastomer (TPE) compound designed for injection molding applications.

**GENERAL PROPERTIES**

<b>Material Status</b>	Active
<b>Availability</b>	Europe North America Asia- Pasific Africa & Middle East
<b>Features</b>	Ozone Resistance Adhesion to Polyolefins Recyclable Compliant with RoHS Directive 2011/65/EU
<b>Certification</b>	RoHS
<b>Appearance</b>	Natural
<b>Form</b>	Pellets
<b>Processing Method</b>	Injection

**Physical Properties**

Property	Typical Value (English)	Typical Value (SI)	Test Method
<b>Density</b>	0.90 g/cm³	0,90 g/cm³	ASTM D 792
<b>Durometer Hardness, 3 sec (Shore A)</b>	30.00	30,00	ASTM D 2240
<b>Tensile Strength at Break</b>	522 Psi	3,60 MPa	ASTM D412, Method A
<b>Mod.of Elasticity %100</b>	44 Psi	0,30 MPa	ASTM D412, Method A
<b>Mod.of Elasticity %300</b>	87 Psi	0,60 MPa	ASTM D412, Method A
<b>Elongation at break</b>	1800.00 %	1800,00 %	ASTM D412, Method A
<b>Compression Set (at 73 °F, 22 h)</b>	18.00 %	18,00 %	ASTM D 395, Type 2, Method B
<b>Tear Resistance</b>	91.36 lbf/in	16,00 N/mm	ASTM D624

**Shrinkage**

Property	Typical Value (English)	Typical Value (SI)	Test Method
<b>Flow</b>	5.04%	5.04%	ASTM D955
<b>Across Flow</b>	1.44%	1.44%	ASTM D955

**Ageing Tests**

Additional Information	Typical Value (English)	Typical Value (SI)	Test Method
Ozone Resistance-Stressed			ASTM D 1149

**Bondable to**

PE-EVA-PS

**Additional Information**

Elastron products are not compatible with PVC and Acetal.  
Regrinding level up to %20 is recommended with minimum property loss.

Injection Molding	Typical Value (English)		Typical Value (SI)	
Drying temperatures	-	°F	-	°C
Drying time	No need	hours	No need	hours
Rear Zone temp.	284-302	°F	140-150	°C
Middle Zone temp.	293-320	°F	145-160	°C
Front Zone temp.	302-329	°F	150-165	°C
Nozzle Temperature	329-365	°F	165-185	°C
Injection Speed	Low	-	Low	-
Injection Time	3-5	sec.	3-5	sec.
Injection Pressure	10-40	bar	10-40	bar
Hold Pressure	5-20	bar	5-20	bar
Back Pressure	5-40	bar	5-40	bar
Screw Speed	50-200	rpm	50-200	rpm
Mold Temperature	77-122	°F	25-50	°C
Screw Comp. ratio	1.5:1- 2.0:1	-	1.5:1- 2.0:1	-
Screw L/D ratio	18-24	-	18-24	-
Residence time	1-2 shot	-	1-2 shot	-
Cushion size	0.3120	inc	8	mm
Suggested Max Regrind	-	%	-	%

Extrusion Molding	Typical Value (English)		Typical Value (SI)	
Drying temperatures	-	°F	-	°C
Drying time	-	hours	-	hours
Screw Comp. Ratio	-	-	-	-
Screw L/D	-	-	-	-
Feed Zone temp.	-	°F	-	°C
Rear Zone temp.	-	°F	-	°C
Center Zone temp.	-	°F	-	°C
Front Zone temp.	-	°F	-	°C
Head temp.	-	°F	-	°C
Die temp.	-	°F	-	°C
Suggested Max Regrind	-	%	-	%

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## ISO 9001: 2015 & IATF16949: 2016 & ISO 14001: 2015 REGISTERED QUALITY SYSTEMS

